

Date: Thursday, 8/30/2007 3:51:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 34370		Part Number	: D2574		
Estimate Number	: 10534		Drawing Number	: D2574 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	8/30/2007	S.O. No.	: N/A			
Prsht Rev.	: NC		Drawing Revision	: E		
First Issue	: N/A		Material	: N/A		
Previous Run	: 33043		Due Date	: 9/21/2007		
Written By	:		Qty:	8	Um:	Each
Checked & Approved By	:		Signature: 07.08.31			
Comment	:		Est Rev: As Per RevE 06-01-27 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: 1531388 SC 07-09-26 (8)		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 34370 Double check by:		

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks.
 5-Tumble to remove sharp edges.

07/10/02

8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 07/10/02 8		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 07/10/02 8		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:51:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 34370

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 07/10/03

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(8X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/10/03

7.0 POWDER COATING POWDER COATING



M105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

41

07-10-03

(X)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/04 60

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54434

PACKAGING RESOURCE #1



10.0 QC21 FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

07/10/04

Job Completion



U 07/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34370
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

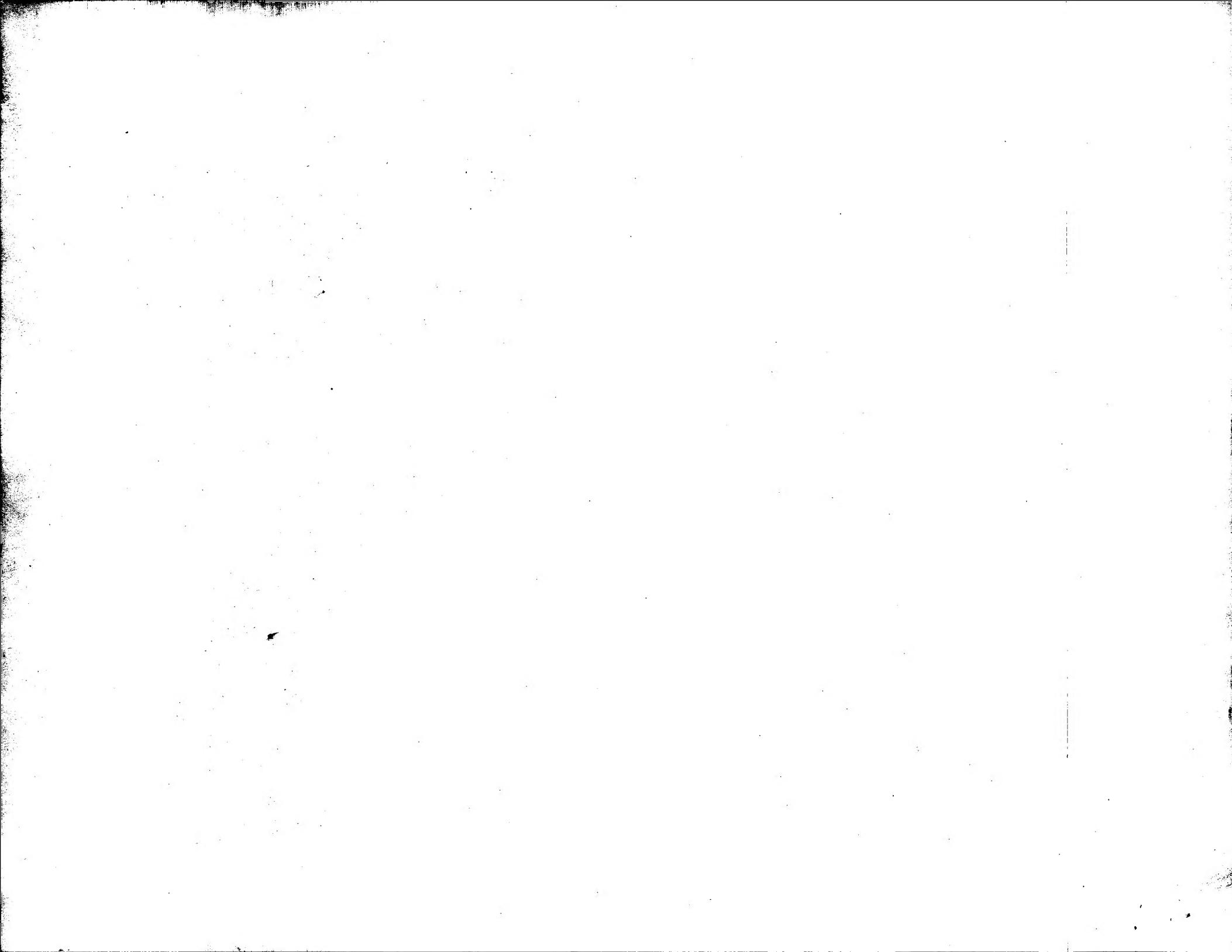
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	-DT8682-	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.001	7.998		
F	0.490	0.510		0.500	0.501	0.502	0.504		
G	0.257	0.262	-DT8683-	0.258	0.259	0.259	0.259		
H	0.375	0.380	-DT8684-	0.376	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.502	0.499	0.501		
J	1.174	1.184		1.178	1.178	1.178	1.179		
K	0.558	0.578		0.570	0.570	0.569	0.569		
L	1.174	1.184		1.178	1.178	1.178	1.179		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	4.119	4.129		4.122	4.121	4.122	4.122		
P	0.115	0.135		0.124	0.124	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.250	0.252	0.254		
S	0.115	0.135		0.126	0.134	0.118	0.115		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.236	3.230	3.230		
V	0.230	0.250		0.234	0.235	0.232	0.238		
W	0.115	0.135		0.135	0.126	0.130	0.121		
X	0.307	0.312		0.312	0.311	0.312	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.364	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.245	0.249		
AE	1.500	1.520		1.514	1.514	1.513	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.267	0.275	0.260	0.250		
AH	0.240	0.260		0.244	0.245	0.245	0.251		
AI	2.000	2.020		2.004	2.004	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *John*
Date: 07/10/03

Audited by: *JL*
Date: 07/10/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>JK</i>	



DART AEROSPACE LTD				Work Order: 34370
Description: Saddle, Aft Inboard				Part Number: D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.446	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.006	8.000		
F	0.490	0.510		0.503	0.503	0.501	0.500		
G	0.257	0.262	DT8683	0.259	0.258	0.258	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.503	0.501	0.502		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		0.570	0.570	0.570	0.570		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.506	2.500	2.500	2.506		
O	4.119	4.129		4.122	4.120	4.121	4.121		
P	0.115	0.135		0.125	0.124	0.124	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.252	0.251	0.251		
S	0.115	0.135		0.116	0.117	0.117	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.228	3.230	3.230		
V	0.230	0.250		0.240	0.239	0.239	0.234		
W	0.115	0.135		0.119	0.118	0.129	0.126		
X	0.307	0.312		0.309	0.310	0.310	0.310		
Y	0.760	0.765		0.766	0.762	0.760	0.760		
Z	0.352	0.372		0.360	0.364	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.245	0.244		
AE	1.500	1.520		1.512	1.512	1.513	1.516		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.242	0.247	0.250	0.260		
AH	0.240	0.260		0.253	0.249	0.250	0.244		
AI	2.000	2.020		2.003	2.002	2.003	2.008		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>JM2</i>	Audited by:	<i>J.L</i>
Date:	<i>07/10/02</i>	Date:	<i>07/10/03</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i>	<i>JL</i>

